

**Work Order ID 71306**

Tuesday, June 28, 2011 8:15:10 AM



Page 1

Item ID: D2873-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Assembly

Start Date: 6/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 7-06-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2873

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 3.700" long

OK 11/06/30

20 ~~0~~

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg. D2873 Identify as D2873-3  
Dwg Rev A Folio Rev AA

OK 11/07/04

20 ~~0~~

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK 11/07/04

20 ~~0~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

*Tuesday, June 28, 2011 8:15:10 AM*

Page 2

[illegible][illegible]

1. *What is the purpose of this study?*

2. *What are the research objectives?*

3. *What is the research methodology?*

4. *What are the results of the study?*

5. *What are the conclusions of the study?*

6. *What are the implications of the study?*

7. *What are the limitations of the study?*

8. *What are the future research directions?*

9. *What are the contributions of the study?*

10. *What are the key findings of the study?*

11. *What are the main results of the study?*

12. *What are the primary outcomes of the study?*

13. *What are the secondary outcomes of the study?*

14. *What are the tertiary outcomes of the study?*

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**Reference:**

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**Insp.  
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0.00

## Quality Control

0.00

**Abstract**

### Small Fab

0.00

## Small Fab

1-Deburr □ 2- C'sink as per Dwg D2873

0.00

[illegible]

0.00

## Quality Control

can't

₹ 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 71306**

Tuesday, June 28, 2011 8:15:10 AM



Page 3

Item ID: D2873-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Assembly

Start Date: 6/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

20  $\phi$  BL 11-3-6.

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20x  $\phi$  M-14/07/26

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 ☐ 2-Identify as D2873-043

EP 11/07/12 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71306

Tuesday, June 28, 2011 8:15:10 AM



Page 4

Item ID:	D2873-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Nut Plate Assembly					
Start Date:	6/28/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	7/11/2011	Req'd Qty:	20.00		Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC5- Inspect part completeness to step on W/O	0.00				<i>counted</i>			
		<i>0.00</i>				<i>x20</i>			
QC	Memo								
Quality Control									

200	Identify as per dwg & Stock Location: <i>X-tube</i>	0.00							
		<i>0.00</i>							
Packaging	Memo								
Packaging									

210	QC21- Final Inspection - Work Order Release	0.00							
		<i>0.00</i>							
QC	Memo								
Quality Control									

*11/7/13*

*ME*

*11-07-12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, June 28, 2011 8:15:02 AM

Page 1

Work Order ID: 71306

Parent Item: D2873-043

Parent Item Name: Nut Plate Assembly



Start Date: 6/28/2011

Required Date: 7/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS21075L5		Purchased	No			100	Each	26.0000	3	60			
Nut Plate													

Location	Loc Qty	Loc Code
ST303	26	
116914	1	
117557	25	

M6061T6B0.375X01.00 0		Purchased	No			180	f	27.4166	0.3083	6.490526			
6061T6 BAR .375 x 1.00													

Location	Loc Qty	Loc Code
MAT002	27.4166	
116963	7.4166	
117653	20	

MS20426AD4-6		Purchased	No			180	Each	1,383.000	6	120			
Rivet													

Location	Loc Qty	Loc Code
ST317	1383	
110139	583	
117505	800	

*Handwritten notes:*

- 6/31/07/12
- M118267 (35)
- 6.3 11/06/36
- 6/31/07/12
- 120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	71306
<b>Description:</b> Radius Block		<b>Part Number:</b>	D2873-3
<b>Inspection Dwg:</b> D2873 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	—		Vern	M2-7
2.000	+/-0.010	2.000	—		"	"
0.750	+/-0.010	.750	—		"	"
1.000	+/-0.010	1.000	—		"	"
0.250	+/-0.010	.250	—		"	"
1.000	+/-0.010	1.000	—		"	"
2.000	+/-0.010	2.000	—		"	"
3.000	+/-0.010	3.000	—		"	"
Ø0.128	+0.005/-0.001	Ø.131	—		"	"
0.359	+/-0.010	.359	—		"	"
Ø0.316	+0.006/-0.001	Ø.319	—		"	"
1.000	+/-0.010	1.004	—		"	"
0.250	+/-0.010	.254	—		"	"
0.061	+/-0.010	.065	—		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø30x.125	—		"	"

<b>Measured by:</b>	<i>[Signature]</i>	<b>Audited by:</b>	B.A	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	11/07/04	<b>Date:</b>	11/07/05	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue      P/O D2873-043	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

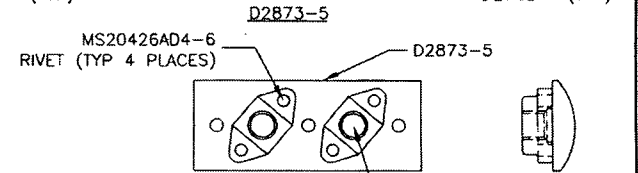
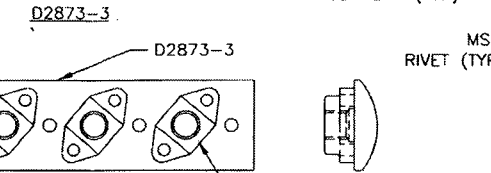
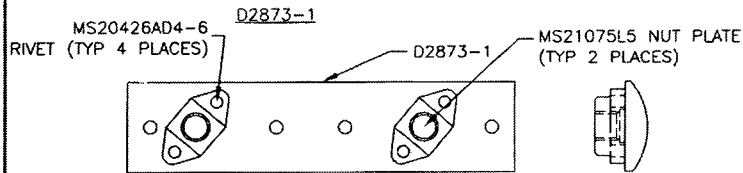
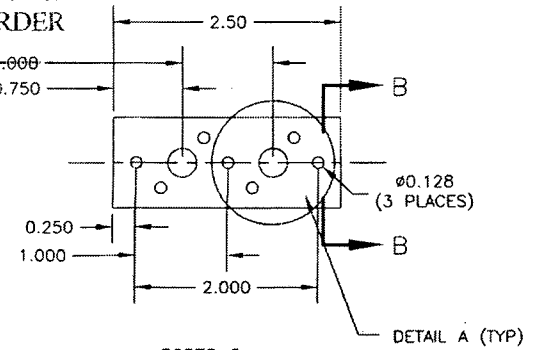
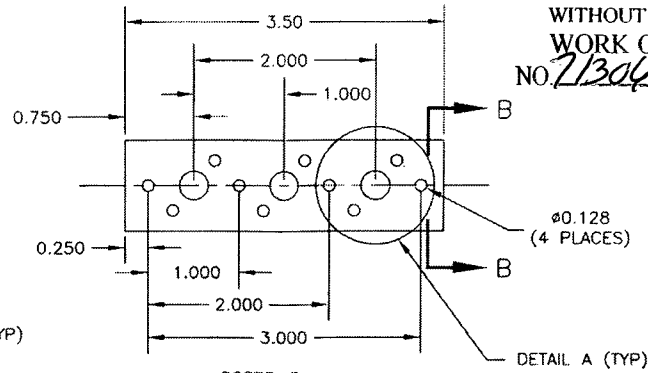
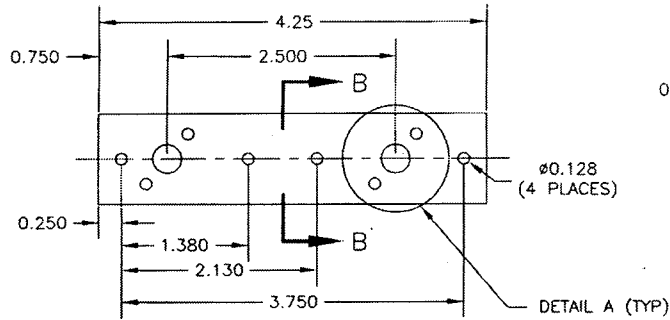
**NOTE:** Date & initial all entries

SHOP COPY  
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UNCONTROLLED COPY

11-06-28

SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 71304



D2873-041

D2873-043

D2873-045

**D2873-1/-3/-5 RADIUS BLOCK**

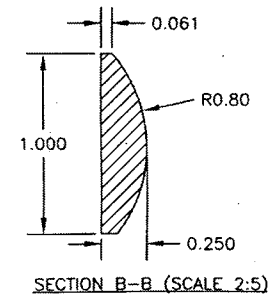
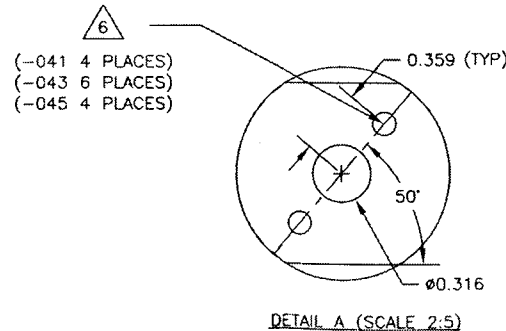
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6)  $\phi 0.128$  PILOT + C'BORE CURVED SIDE  $\phi 0.230 \times 0.125$  DEEP + C'SINK CURVED SIDE  $\phi 0.225 \times 100'$

**D2873-041/-043/-045 NUT PLATE ASSEMBLY**

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

**D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST**

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED  
05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries